

# Work Order ID 87049

**\*87049\***

Page 1

July-10-12 2:59:51 PM

Item ID: D2654-5

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Web

Stop

**\*NS2\***

Start Date: 10/07/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 24/07/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/07/10

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2654

F

100

0.00

**\*100\***

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut D2600-7 to length as per Dwg D2654  
2-Drill pilot holes in web using drill jig DT 8018-5 as per Dwg D2654  
3-Using the uni-bit, open holes to finish size as per Dwg D2654  
4-Deburr holes and ends

4 SAD ~~12-10~~  
12-07-11

110

QC5- Inspect part completeness to step on W/O

0.00

**\*110\***

QC

Memo

0.00

Quality Control

4 0 BE 12-07-11

120

Chemical Conversion Coat per QSI005 4.1

0.00

**\*120\***

HandFinish

Memo

0.00

Hand Finishing

4 MB 12-7-11

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/7/13	100	Qty(3) of the beams have the fwd-most and aft-most hole off by $\approx 1/8"$ RC sig was starting to wear out	CP 12/7/13	Acceptable to open holes up to $\phi 0.650$ to allow <del>xxx</del> x-bolt spacers to install.  <del>Replace Jcy. DT 8018-5</del>	OC 12/7/13	CF 12-7-16	CP 12/7/13	DAS 16 12/16/16

NOTE: Date & initial all entries

# Work Order ID 87049

**\*87049\***

Page 2

July-10-12 2:59:51 PM

Item ID: D2654-5

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Web

Start Date: 10/07/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 24/07/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC7-Inspect Chemical Conversion Coat	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>LG</u>	0.00							
<b>*140*</b>									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

4 SAD B-0712

4 CF 12-1-12

MLJ 12/07/16

MLJ 12/07/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 87049

\*87049\*

Parent Item: D2654-5

\*D2654-5\*

Parent Item Name: Web

Start Date: 10/07/2012

Required Date: 24/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D 99.02.04 Fixed typo, Changed procedureDM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-7-140

Manufactured

No

100

Each

128.0000

1

4

\*D2600-7-140\*

\*\*

SAD 12-07-11

EXT. "I BEAM" THICK

Location

Loc Qty

Loc Code

LG

128

41591

3

72279

125

4

**Dart Aerospace Ltd**

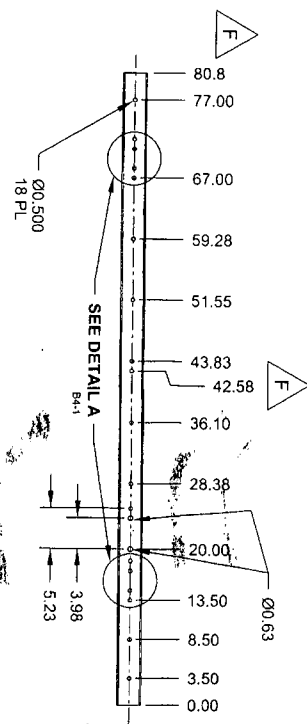
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D2654-3 WEB**

BE-2	REV.	DESCRIPTION	DATE
B3-2	A	NEW ISSUE	97.03.25
D3-2	B	ALTER HOLE PATTERN, 0.500 WAS 0.438	97.08.26
D3-1	C	CHANGED HOLE PATTERN	97.10.29
C3-1	D	GIW HOLES CHANGED TO 80.63	98.01.15
C3-1	E	CHANGE LENGTHS, REFORMAT	CP 04.05.26
F	F	ADDED ADDITIONAL HOLES ON -54.7, 80.8 WAS 80.5, INCORPORATED DEO D2864-E-2	SC 11.03.05

DESIGN	CP	<b>DART AEROSPACE USA, INC</b>	
DSAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>W</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>EE</i>	D2654	SHEET 1 OF 2
APPROVED	<i>W</i>	TITLE	SCALE
DE APPR.	<i>W</i>	WEB	NTS
DATE	11.05.05	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. ALL RIGHTS RESERVED. NO PART OF THIS DRAWING IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.	

2011-09-12 AM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

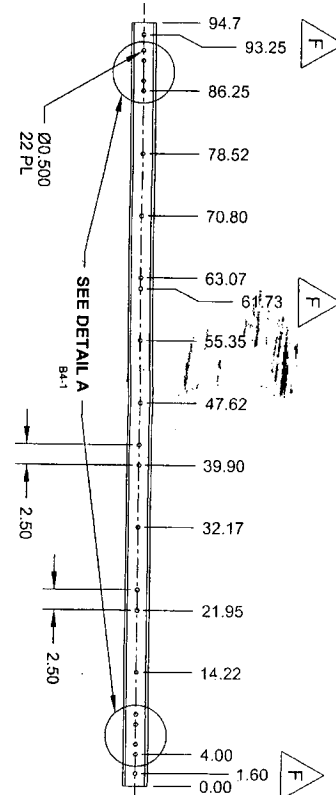
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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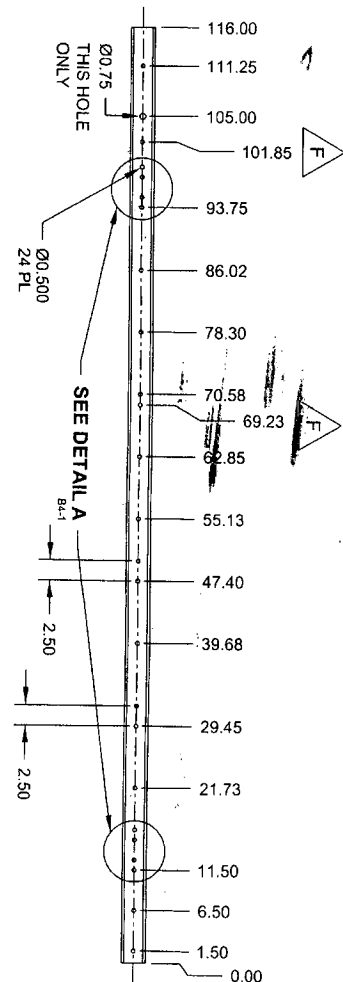
**NOTE:** Date & initial all entries





D2654-5 WEB

27049



D2654-7 WEB

RELEASED  
2011-09-12

DESIGN	CP	DART AEROSPACE USA, INC
DRAWN	SC	PORT HADLOCK, WA
CHECKED	Q	DRAWING NO.
MFG. APPR.	Q	D2654
APPROVED	Q	TITLE
DE APPR.	Q	WEB
DATE	11.05.05	SCALE
		NTS

CONTRACT & 1007 BY DART AEROSPACE USA, INC  
NOT TO BE USED FOR ANY OTHER PURPOSE WITHOUT  
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC

W/O:		WORK ORDER CHANGES					
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